




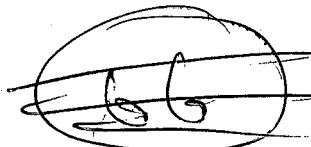









Date: Tuesday, 23/09/2008 10:22:14 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 42225	
Estimate Number : 12559	
P.O. Number :	Part Number : D32381
This Issue : 23/09/2008 S.O. No. :	Drawing Number : D3238 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33511	Material :
Written By :	Due Date : 20/10/2008 Qty: 60 Um: Each
Checked & Approved By : <u>JLD 08.9.23</u>	
Comment : Est Rev:A New Issue 06-10-20 EC	
Est Rev:B Now on Waterjet 07-01-26 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M2024T3S080 2024-T3 .080 sheet
	 
Comment: Qty.: 0 sf(s)/Unit Total : 1 sf(s) 2024-T3 .080 sheet batch: <u>109242</u> <u>IB 8-10-2</u>	
2.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut Blank file in D3238 Dwg Rev: <u>C</u> <u>IB 8-10-2</u> Prog Rev: <u>C</u>  2-Deburr if necessary	
3.0	MILLING CONV. CONVENTIONAL MILLING MACHINE
	 
Comment: CONVENTIONAL MILLING MACHINE Mill serations using DT8934 <u>IB 08/10/09</u>	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 08/10/09</u>	
5.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D3238 <u>IB 8-10-7</u>  Dwg Rev: <u>C</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:14 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 42225

Part Number: D32381

Job Number:



Seq. #:

Machine Or Operation:

Description :

Prog Rev: C

2-Deburr if necessary

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-10-7



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK



counted

Comment: SECOND CHECK

S 08/10/09 (66)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(66X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/10/10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/8 08/10/10 (66)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST78

AS 08/10/10 (66)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/10 (66)

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-10-10

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



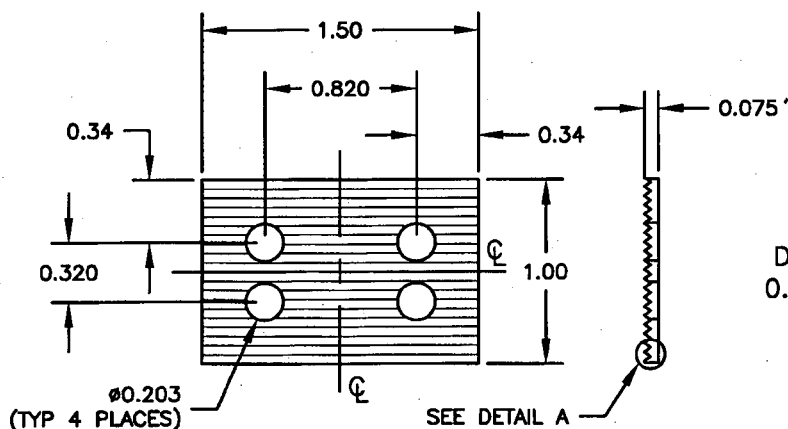
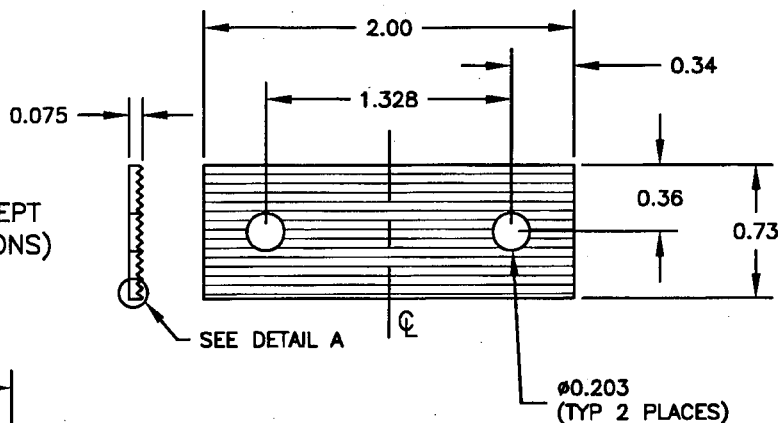
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)

D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)

D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

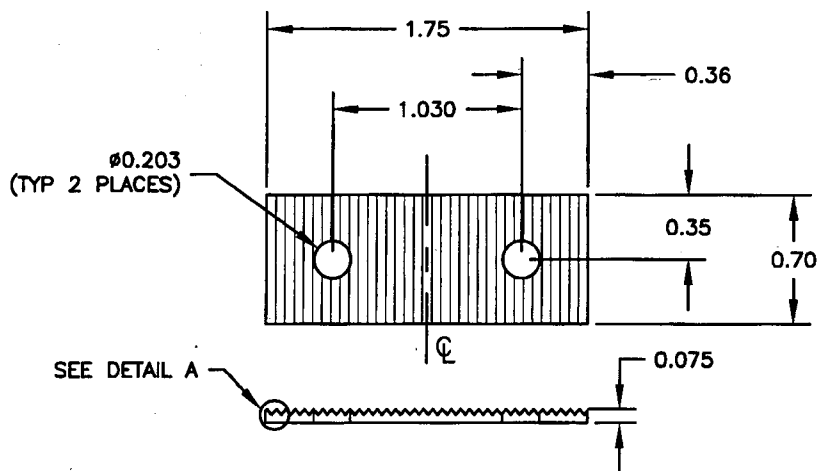
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WORK ORDER
NO. 42225

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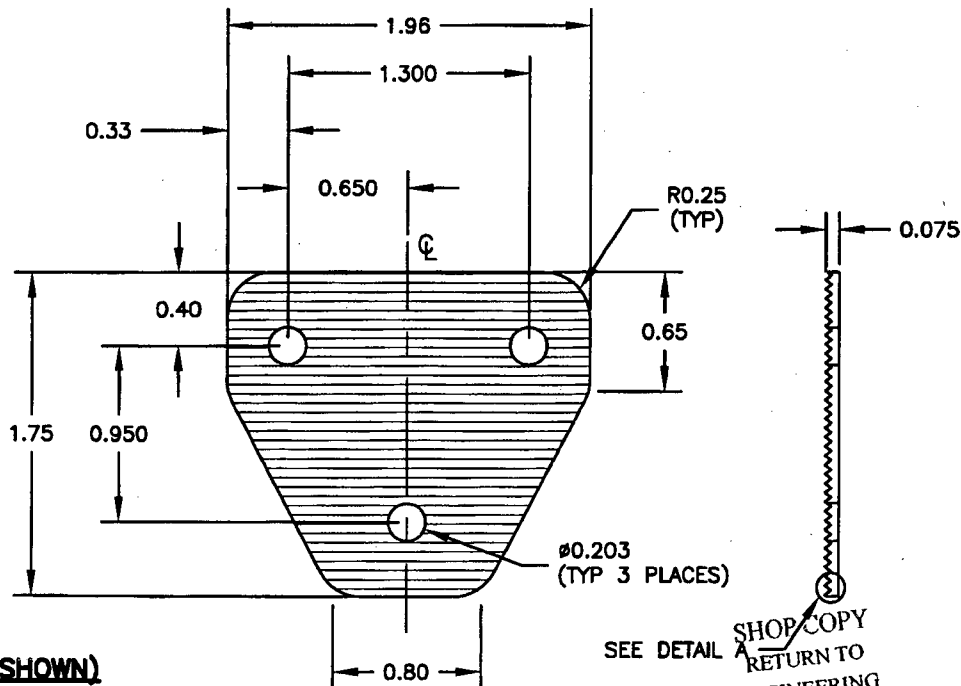


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1



RELEASED
07.02.20 #

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

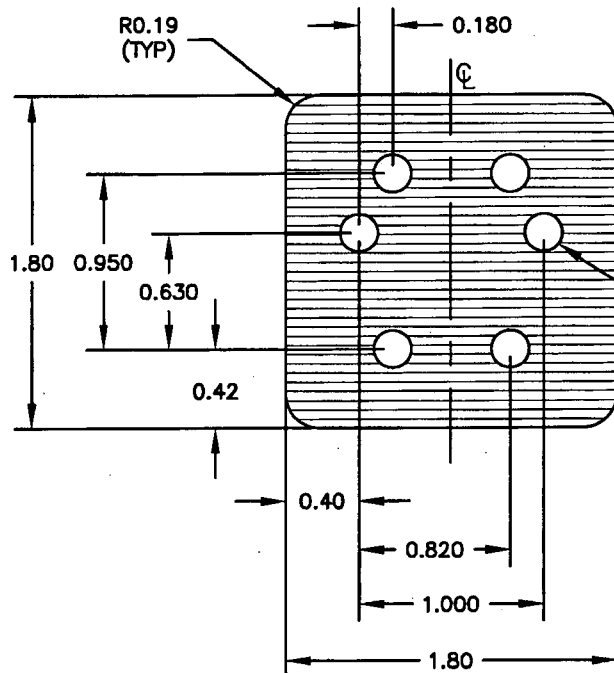
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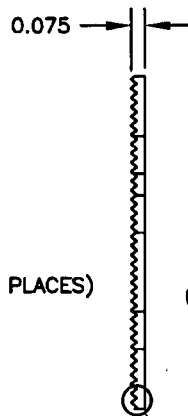
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



Ø0.203
(TYP 6 PLACES)

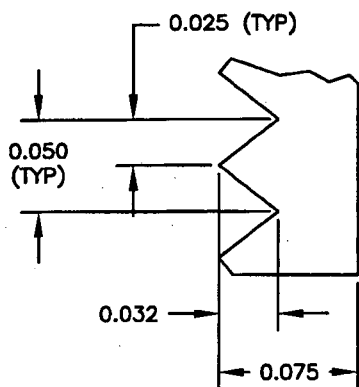


SEE DETAIL A

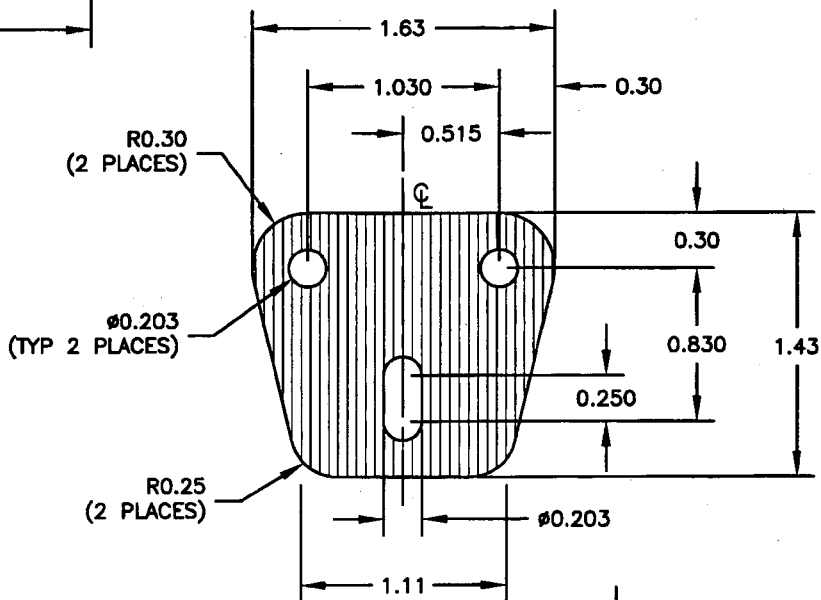
RELEASED

07.02.20

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



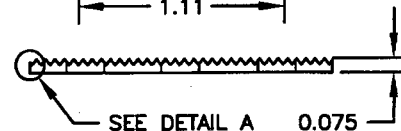
DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



R0.30
(2 PLACES)

Ø0.203
(TYP 2 PLACES)

R0.25
(2 PLACES)



SEE DETAIL A

D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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DART AEROSPACE LTD	Work Order: 42225
Description: PLATE	Part Number: D3238-1
Inspection Dwg: D3238-1, Rev: C	Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

X First Article

x	Prototype
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[illegible]

Measured by:	B
Date:	8-10-7

Audited by:	
Date:	08/01/05

Prototype Approval:	<i>h</i>
Date:	<i>h</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	